

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

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OTHER : _____																									

Work Order ID 146140

Friday, May 06, 2016 9:00:55 AM

146140

Page 3

Item ID: D3691-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Stud

Start Date: 5/9/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/19/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
175	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
175									
QC	Memo	0.16							
Quality Control									AUG 19 2016
180	Identify as per dwg & Stock Location: <u>51231A</u>	0.00							
180									
Packaging	Memo	0.08							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.80							
Quality Control									

2727DAS
21
9-89DAS
21
9-89DAS
21
9-89

AUG 22 2016

AUG 22 2016

AUG 19 2016

AUG 19 2016

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OTHER : ☐																									

Picklist Print

Friday, May 06, 2016 9:00:54 AM

Page 1

Work Order ID: 146140

146140

Parent Item: D3691-1

D3691-1

Parent Item Name: Stud

Start Date: 5/9/2016

Required Date: 5/19/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 08-01-29 JLM Verified By:EC
IPP Rev:B Material Change 09-01-07 JLM Verified By:EC IPP
REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
IPP Rev:C Added note on Step 2 09-01-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R1.000		Purchased		No			f	55.5000		5.842922	14.60		
M174PH-H900R1 000									**				
17-4SS H900 ROUND BAR 1.00													

Location	Loc Qty	Loc Code
MAT031	55.5	
m127334	16.5	
m128314	39	

14.0 ~~14~~
6.5 ~~6.5~~
20.5 ~~20.5~~
DAS
45 2016-7-27
9-89

DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	146140
Description: Stud		Part Number:	D3691-1
Inspection Dwg: D3691		Rev: E	Page 1 of 1

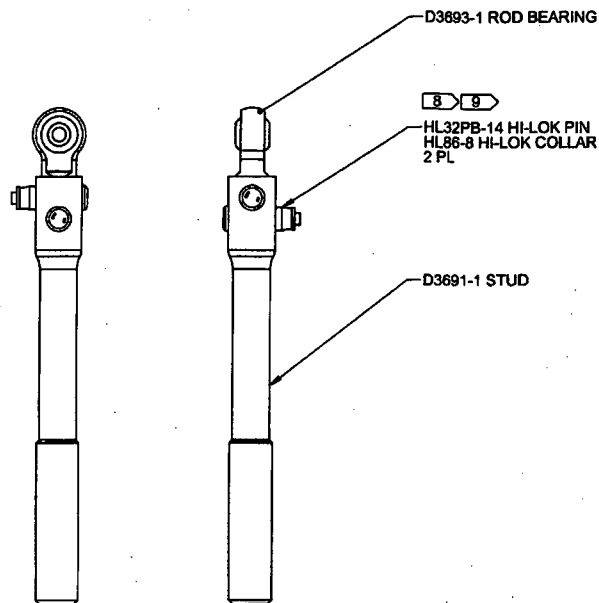
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.695	+/-0.010	0.692	✓		caliper	ITC-1
45°	0.5°	45°	✓		ang 6	Shop
0.623	+0.004/-0.000	0.625	✓		pin	Shop
1.25	+0.000/-0.03	1.2325	✓		caliper	ITC-1
118°	0.5°	118°	✓		ang 6	Shop
R0.03	+/-0.030	r.03	✓		radk	Shop
0.11 Ref	+/-0.030	0.11	✓		caliper	ITC-1
90°	0.5°	90°	✓		ang 6	Shop
Ø0.216	+0.005/-0.001	0.217	✓		caliper	ITC-01
1.31	+/-0.030	1.31	✓		li	"
1.65	+/-0.030	1.65	✓		"	"
0.750	+0.000/-0.010	0.744	✓		"	"
Ø0.659	+0.000/-0.015	0.6503	✓		MTCO-1	ITC-2
7.625	+/-0.015	7.624	✓		Caliper	ITC-1
2.90	+/-0.030	2.900	✓		"	"
3/4-16UNF-2A	N/A	OK	✓		PART CONFORMS	Shy
0.075 x 45°	+/-0.010 x 0.5°	0.075 x 45°	✓		depth 6	ITC-7
0.375	+0.000/-0.010	0.369	✓		HG	31006
Ø0.216	+0.005/-0.001	0.217	✓		caliper	ITC-1
R0.25	+/-0.030	r.250	✓		radk	Shop
R0.50	+/-0.030	r.500	✓		"	"
Ø0.825	+/-0.010	0.8275	✓		mic-1	JK-02

Measured by:	DAS 45 9-89	Audited by:	DAS 44 9-89	Preliminary Approval:	
Date:	2016-7-27	Date:	16-07-31	Date:	

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	09.11.04	Dwg Rev updated	KJ	
C	10.03.31	Dimensions revised per Dwg Rev D	KJ	
D	13.02.27	Ø0.216 was Ø0.189	KJ	
E	13.11.04	Dimensions revised	KJ	

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3691-041	STUD ASSEMBLY
2	1	D3691-1	STUD
3	1	D3693-1	ROD END BEARING
4	2	HL32PB8-14	HI-LOK PIN
5	2	HL86-8	HI-LOK COLLAR



E D3691-041 STUD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.04 lbs
- 8) ALIGN THE PILOT HOLES IN D3693-1 WITH PILOT HOLES IN D3691-1. ENLARGE EACH HOLE USING A P/N 13-420 PILOTED DRILL (0.2314 DIA./0.2158 PILOT). REAM EACH HOLE USING A P/N 44-300 STEP REAMER (0.247 DIA./0.2314 PILOT). CLEAN AND DEBURR ALL HOLES PRIOR TO ASSEMBLY.
- 9) ASSEMBLE D3693-1 WITH D3691-1 USING HYSOL EA934NA OR MAGNOBOND 8398 ADHESIVE BETWEEN MATING SURFACES.

E	ADD -041 STUD ASSEMBLY, ASSEMBLY INSTRUCTIONS (ZN A8-1, ZN B6-1, ZN D7-1). Ø0.216 WAS Ø0.189 (ZN D2-2, D4-2). Ø0.823 WAS Ø0.825 (ZN D7-2). RE-FORMAT NOTES SECTION AS PER QSI 043 (ZN A8-1), REF NCR 12-2074.		DB	12.12.07
D	7.825 WAS 7.750 (ZN C4-1)		RF	10.03.03
C	0.29 WAS 0.16 & CENTER DRILL #4 WAS CENTER DRILL #2 (ZN B6-1). UPDATE NOTE 8 TO REF QSI (ZN A8-1)		RF	09.09.09
B	CHANGE TO 17-4PH H-900 (ZN A8-1). Ø0.695 WAS Ø0.685 (ZN D8-1). REFORMATTED TO CURRENT DWG STANDARDS		RF	08.11.24
A	NEW ISSUE		RF	08.03.12
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	DB			
CHECKED	MB	DRAWING NO.	REV. E	
MFG. APPR.	JLM	D3691	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		STUD	NTS	
DATE	12.12.07	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

w/o 146140

2m 16/05/09

22.11.19

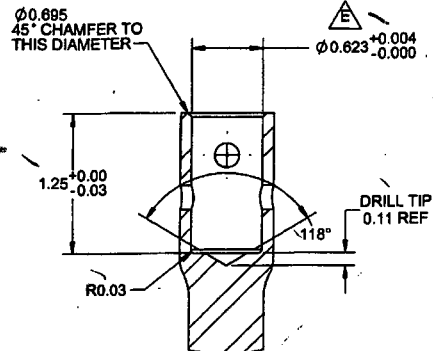
22.11.19

22.11.19

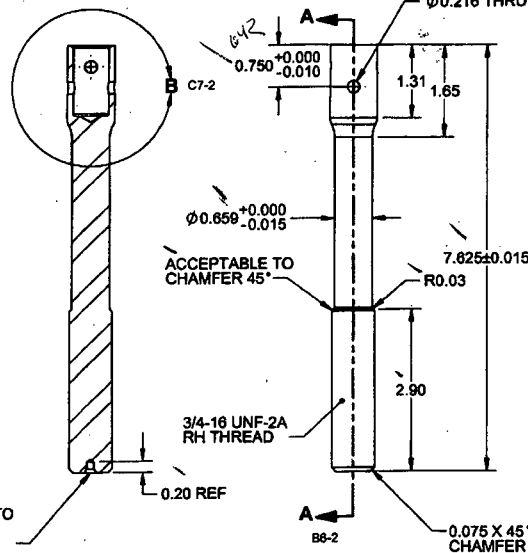
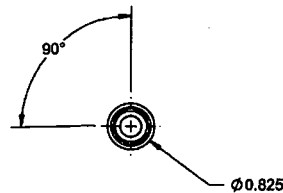
22.11.19

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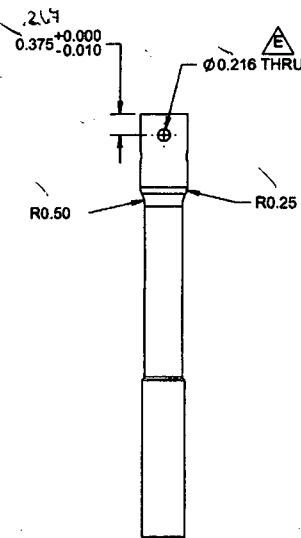
22.11.19



DETAIL B
SCALE 1:1



SECTION A-A



RELEASED
2013-01-22

- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.80 lb
 - 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	JLM	D3691	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STUD	NTS
DATE	12.12.07	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

OUTSTANDING PO REPRINT

Purchase Order ID PO33278

Purchase Order Date 8/9/2016

PO Print Date 8/19/2016

Page Number 1 of 1

Order From : VC-SKY001
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

Ship To : DART AEROSPACE LTD
1270
ABERD
EEN
HAWKE
SBURY,
ON
K6A
1K7
CANAD
A

Contact Name
Vendor Phone 905-678-5636
Vendor Fax 905-678-5841
Ship To Contact
Ship To Phone

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Ship Method Delivered
Ship Acct

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
7	146140	D3691-1 STUD	8/19/2016 Yes 8/19/2016	27.00 <i>19/8/16 SP</i>	\$178.00
LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2					

Line Total: \$178.00

Outstanding PO Total: \$178.00

Change Nbr: 4

Change Date: 8/19/2016

CL
Terms & Condition of
Purchasing(Suppliers) and
Procurement Quality Clauses are an
integral part of our AS9100

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.742 / BDA AMO 385

WO #: MWO29127	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 33278
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	

Task: **UNSCHEDULED**

Sequence:

Work Required:

CARRY OUT NDT ON 27 STUDS, ITEM ID# D3691-1, WORK ORDER ID# 146140 AS PER PO33278

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13 ***NO CRACK FOUND*** PEN ZL-37, MPO13139, CLEANER SKC-S MPO15030, EMU. MPO15896, DEV. MPO15030, UV LIGHT M-20142						AUG 12 2016	
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RARIK MELIKIAN		AUG 12 2016